

Date: Wednesday, 27/09/2006 2:00:07 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE BRACKET
Job Number : 28749	
Estimate Number : 12254	
P.O. Number : N/A	Part Number : D34813
This Issue : 27/09/2006 S.O. No. : N/A	Drawing Number : D3481REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 27027	Material : N/A
Written By : <u> </u>	Due Date : 04/10/2006 Qty: 6 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:A New Issue 06-02-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3481

Dwg Rev: AProg Rev: A

MM *06 10 02*

⑥

2.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.0515 sf(s)/Unit Total: 0.3087 sf(s)

304/316 0.018 SHEET

(m304s26ga)

Batch: 11/01/000

MM *06 10 02*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM

06 10 02

⑥

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

20 10 03

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D3481

SB *06/10/03*

⑥

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 06/18/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/09/2006 2:00:07 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE BRACKET

Job Number: 28749

Part Number: D34813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Joe 10-03



⑥

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 06/10/03

⑥

8.0

QC21

FINAL INSPECTION/W/O RELEASE



⑥

Comment: FINAL INSPECTION/W/O RELEASE

SB 06/10/04

Job Completion



C Loc 10/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

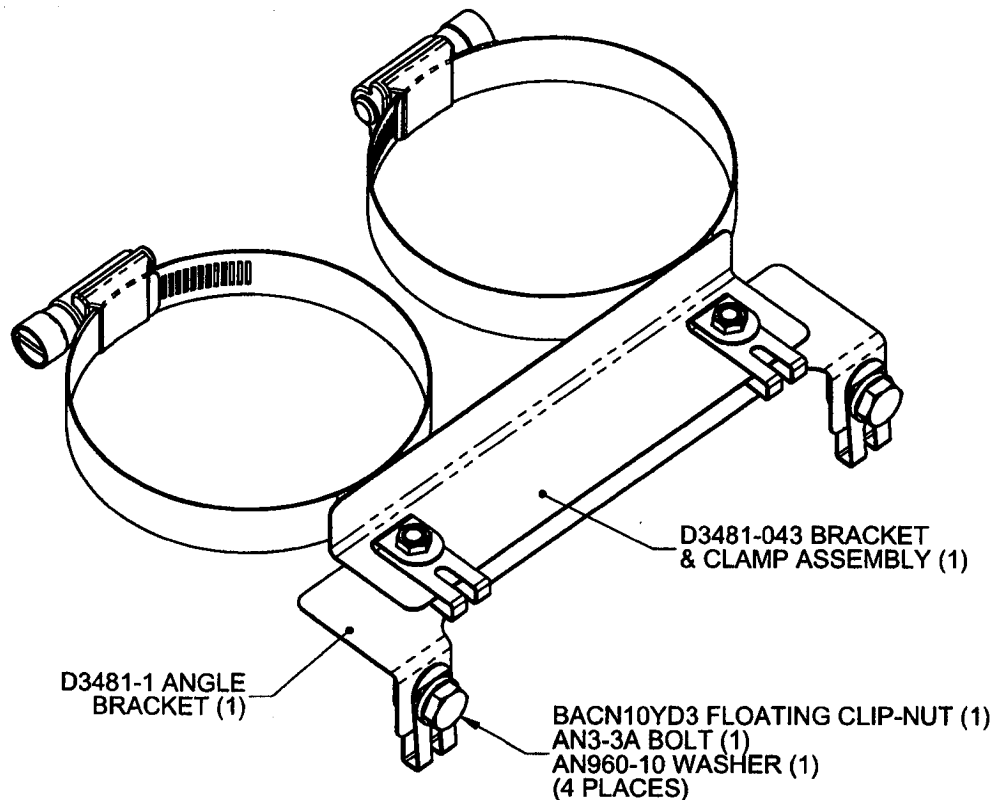
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 2:3
A	06.01.23	NEW ISSUE	

06.04.03

D3481-041 SHUT-OFF VALVE BRACKET

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

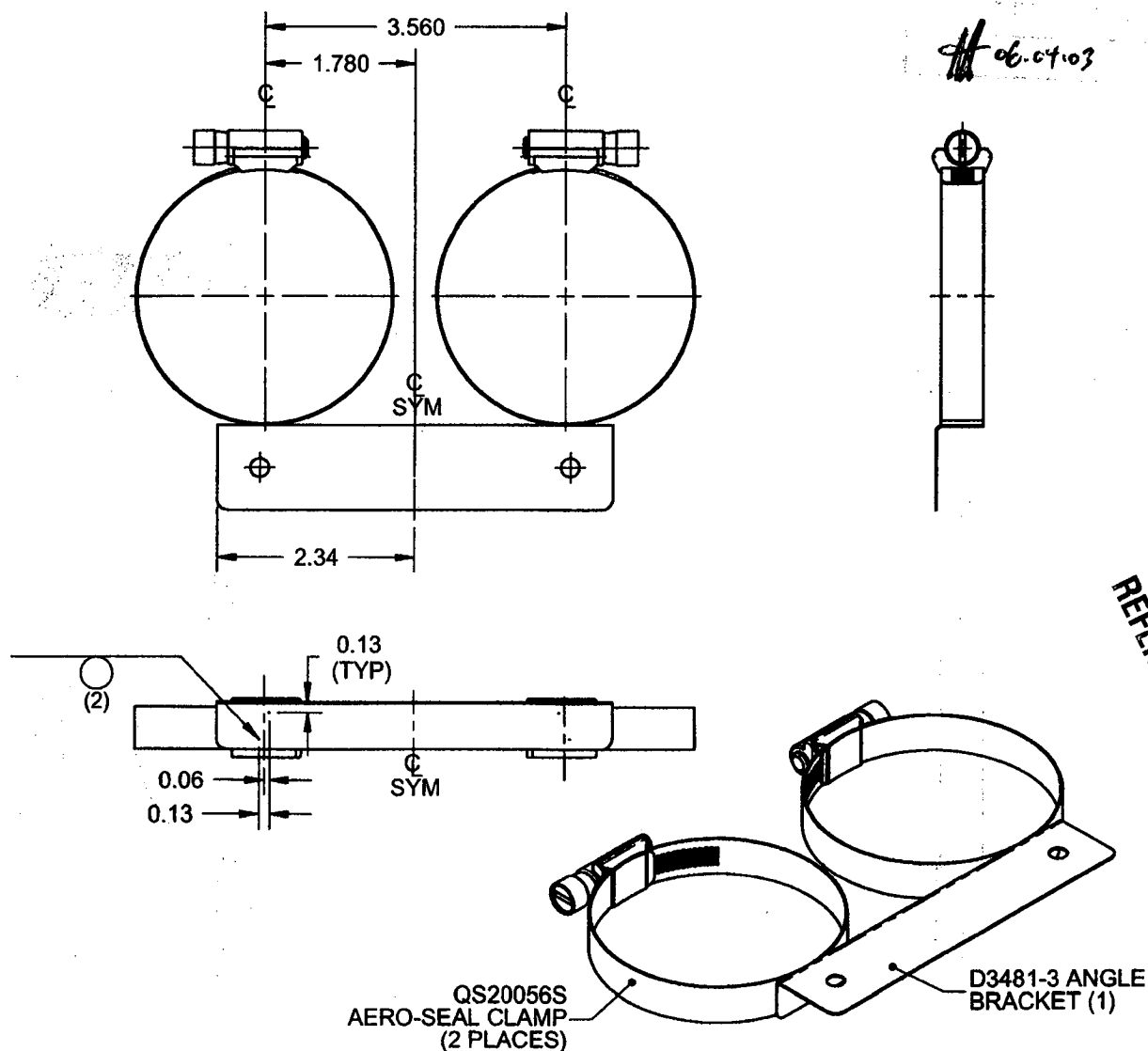
REFERENCE ONLY

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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

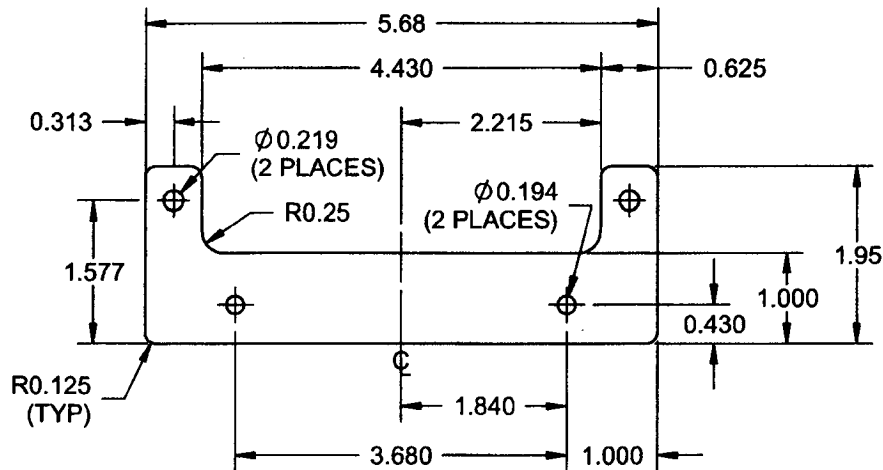
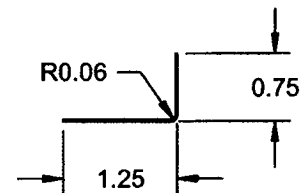
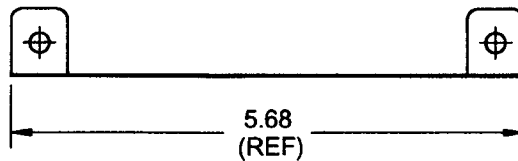
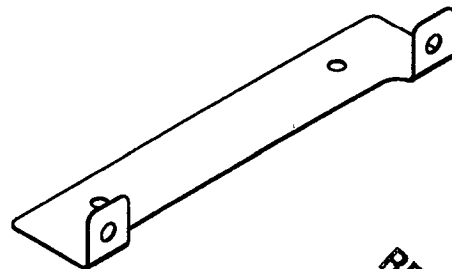
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3481	REV. A SHEET 3 OF 4
DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

**D3481-1F FLAT PATTERN****D3481-1 ANGLE BRACKET***H* 06.04.03**REFERENCE ONLY****NOTES:**

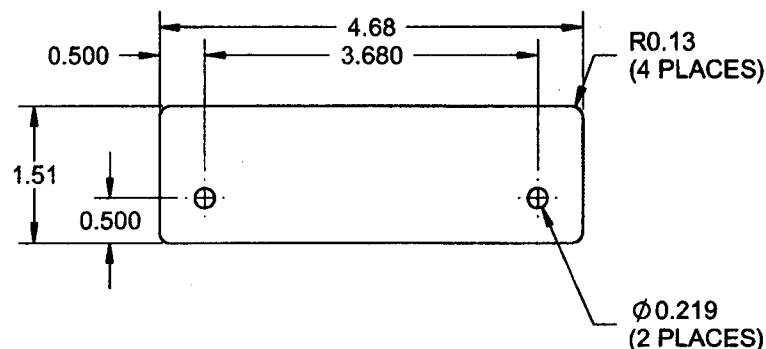
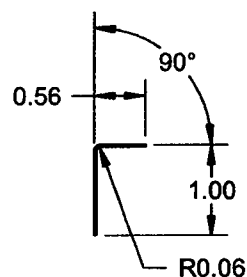
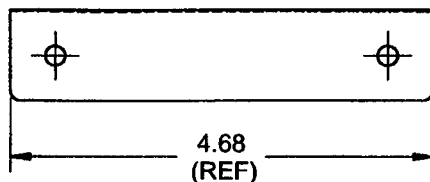
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

[Signature] 06.04.03**D3481-3F FLAT PATTERN****REFERENCE ONLY****D3481-3 ANGLE BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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